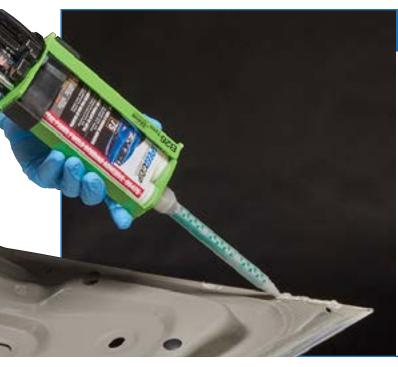


Auto Line



Plastic Repair Seam Sealers N

- Metal Bonding
- · Created using the most advanced technology available today
- Products can handle many different applications, thus minimizing the need for a large inventory of product to be kept on-hand
- Acrylic Adhesives are the best choice for metal-to-metal bonding, giving a lifetime corrosion and performance warranty
- Urethane Adhesives are the best choice for plastic repairs, easy to sand and will not lift, roll up or shrink
- Epoxy Adhesives are ideal for undetectable SMC repairs because they are easy to sand and will not lift or roll up

MEIAL BUNDING
COMPOSITE PLASTIC REPAIR – BUNDING COMPOSITE PLASTIC REPAIR – STRUCTURAL
COMPOSITE PLASTIC REPAIR – COSMETIC
FLEXIBLE PLASTIC REPAIR – STRUCTURAL
FLEXIBLE PLASTIC REPAIR – COSMETIC

METAL B	COMPOS	COMPOS	COMPOS	FLEXIBLE	FLEXIBLE							
MET	COM	COM	COM	9	9	636425-	DESCRIPTION	COLOR	WORK TIME	HANDLING/ CLAMP TIME	SANDING TIME	PAINT TIME
ACRYLIC ADHESIVES												
						06419	Metal Door Skin Bonding	Green	45 min	1-1/2 hrs		
						06420	Metal Panel/Weld Bonding	Gray	75 min	2-1/2 hrs		
EPOXY	EPOXY ADHESIVES											
						06418	Panel Bonder – 30 minute	Black	30 min	2 hours	3 hours	
						06421	Panel Bonder – 90 minute	Black	90 min	4 hours	8 hours	
						06427	Impact Toughened	Purple	90 min	120 min		
						06412	Repair and Filler	Purple	5 min		15-30 min*	15-30 min*
						06417	SMC/Fiberglass Repair	Beige	40 min		10 min @180°F	60 min @180°F
URETH	IANE AD	HESIVE	ES									
						04647	45 second	Opaque	45 sec	2-1/2 min	5 – 7 min*	
						04615	1 minute	Black	1-1/2 min	7 min	12 – 20 min*	1 hour
						04616	5 minute	Black	7 min	15 min	45 min	2 hours
						04617	15 minute	Black	20 min	45 min	90 min	3 hours

TECHNICAL HELP LINE 1-866-879-3761









45 Minute Metal Panel/Weld Bonding Adhesive

Two-part acrylic (2:1) for panel bonding of door panels, other body sheet metal, steel and aluminum. Clamp time: 1-1/2 hours. Cure time: 8 hours.

DESCRIPTION	SIZE	PART #
Panel Bonding Adhesive 2:1	220ml	636425 06419
Case		6



OEM

75 Minute Metal Panel/Weld Bonding Adhesive

Two-part acrylic (2:1) for panel bonding of quarter panels, rear body panels, roof panels, door panels, van side panels and outer truck bed panels on bare metals, including aluminum.

Clamp time: 2-1/2 hours. Cure time: 8 hours.

DESCRIPTION	SIZE	PART #
Panel Bonding Adhesive 2:1	220ml	636425 06420
Case		6



OEM

Impact Toughened Structural Adhesive

Two-part epoxy (2:1) structural adhesive for use in automotive bonding applications. Adheres to a wide variety of properly prepared substrates including steel and aluminum. The Impact Toughened Structural Adhesive has an extended work time for large applications, but can be accelerated with applied heat. Impact Toughened Structural Adhesive is much stronger than traditional structural adhesives, and can be used in weld bonded or rivet bonded OEM applications.

DESCRIPTION	SIZE	PART #
Panel Bonding Adhesive 2:1	220ml	636425 06427
Caco		



Panel Bonding Adhesive

Superior two-part epoxy (2:1) adhesive designed to bond SMC, FRP, fiberglass, steel, and aluminum auto parts and body panels to each other and to metal frames (no primer required). It seals and bonds in one application.

DESCRIPTION	SIZE	PART #
Panel Bonding Adhesive – 30 minute	220 ml	636425 06418
Panel Bonding Adhesive – 90 minute	220 ml	636425 06421
Case		6

TECH TIP

Norton SpeedGrip adhesives SHOULD NOT be used for bonding structural components such as rails, pillars, rocker panels, core supports, etc. If in doubt as to what is a structural component, contact the vehicle manufacturer.

RESISTANCE SPOT WELDING: Norton recommends resistance welding through Metal Bonding Adhesives in a wet or cured state with little to no burn back.

WELDING: Norton Adhesive CANNOT be in the weld area or burn back will occur. Norton recommends at least one inch clearance from the weld site. A one inch clearance will keep the adhesive from contaminating the weld site while positioning the panel on the vehicle. If using, make sure to cover weld area on vehicle and replacement panel, but do not contaminate bond line areas.

After clamping, wipe any excess adhesive off the panel while wet.

